

Thursday, April 13, 2017 2:39:05 PM

Page 1

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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100		0.00		
100				
Waterjet	Memo	0.05	(1)	DC 17/04/19
FLOW CNC Waterjet	***Confirm if parts are trimmed or untrimmed prior to cutting ***			
	Cut as per dwg			
	Prog Rev: <u>P</u>			
	Dwg Rev: <u>P</u>			
	Deburr as required			
			TRIMMED	
110	QC2- Inspect parts off machine FAI/FAIB	0.00		
110				
QC	Memo	0.01	(1)	DC 17/04/19
Quality Control				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																															
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Work Order ID 159633

159633

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Item ID: D4640-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Wall Protector
 Start Date: 4/19/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/21/2017 Req'd Qty: 1.00 *1* Customer:
 Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo USE TEMPLATE TO MARK HOLE LOCATIONS WITH A FINE POINT MARKER ON TEXTURED SIDE	0.00 0.02				1			DAS 38 9-89 APR 19 2017
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>PK</u> Memo	0.00 0.01				1			APR 20 2017 DAS 21 9-89
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							DAS 21 9-89 APR 20 2017 DAS 21 9-89 APR 20 2017

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause		FAULT CATEGORY							
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 159633

159633

Parent Item: D4640-7

D4640-7

Parent Item Name: Aft Wall Protector

Start Date: 4/19/2017

Required Date: 4/21/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC
12.10.17 AS PER REV.B VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased				100	sf	1,075.096	4	4.210526			

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (LIGHT GREY)

04/17/04/19

Location

Loc Qty

Loc Code

MAT023

69.56

m129738

69.56

therm

1005.5366

m135322

199.4

m135517

806.1366

5

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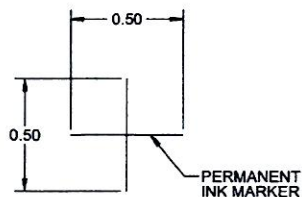


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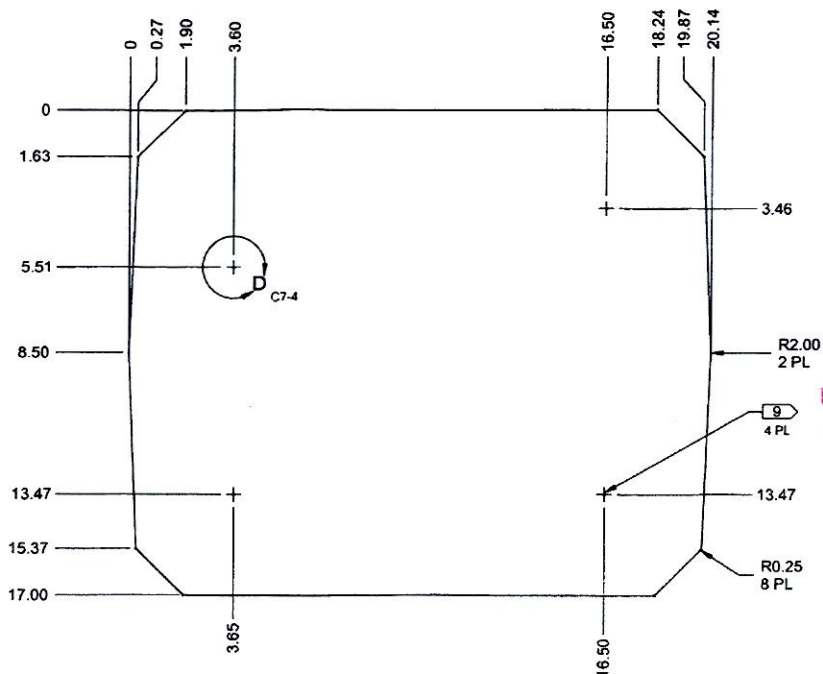
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OTHER : _____					



DETAIL D
NOT TO SCALE
TRIMMED KIT ONLY

0.093
REF



D4640-7 AFT WALL PROTECTOR
TEXTURED SIDE SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159633 N.J.
1704-13

RELEASED
2013-01-10

NOTES:

- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.34 lbs
- 8) CHECK PER TEMPLATE DT8927
- 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER, DRAW 0.50" CROSS
ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4640	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BAGGAGE PROTECTOR	NTS
DATE	12.12.18	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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